

Date: Tuesday, 4/17/2007 11:05:07 AM
User: Kim Johnston

Process Sheet

split 815 07/07/04

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	CLAMP
Job Number	31833		
Estimate Number	11119		
P.O. Number	N/A	Part Number	D30411
This Issue	4/17/2007	S.O. No.	N/A
Prsh Rev.	NC	Drawing Number	D3041 REV.C
First Issue	N/A	Project Number	N/A
Previous Run	26217	Drawing Revision	C
Written By		Material	N/A
Checked & Approved By	<u>KJ</u> 07.04.17	Due Date	4/24/2007
Comment	Est:A 01.07.11 New Issue SM est B 07.04.09 rev.c dwg EC	Qty:	10
		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	D2423	Lug Extrusion	
	Comment: Qty: 0.0875 f(s)/Unit Total 3.4986 f(s)		
	Lug Extrusion (D2423)	Batch: 330062 En 07/04/27	
2.0	BAND SAW	BAND SAW	
	Comment: BAND SAW		
	Cut D2423 Extrusion: 1.250" Long		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
	Comment: HAAS CNC VERTICAL MACHINING #1	Tissue P.O. 3663	
	Machine per folio FA153	Machine per drawing D3041 Rev C 7/04/30	
4.0	QCB	INSPECT PARTS AS THEY COME OFF MACHINE Receive + inspect for transit damage	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QCB	SECOND CHECK	
	Comment: SECOND CHECK	Inspect Level 5	

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Drawing Name: CLAMP

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Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL

07/05/14

50

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M.L

07/05/15

SOT

8.0

POWDER COATING

POWDER COATING



M 103706



60X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask inside of 0.8120" diameter hole

m.l 07/05/16

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



FL

07/05/17

50

Comment: INSPECT POWDER COAT

10.0 D2611

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Bearing

Pick:

Qty	Part Number	Description	Batch
1	D2611	Bearing	B 30914 (20)

B 31038 (30)



11.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- Press D2611 bearing into lug as per Dwg D3041
- 2- Stake bearing into place as per Dwg D3041

SB 07/07/04

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____



Counted
740

Process Sheet

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Part Number: D30411

Job Number:



Seq. #:

Machine Or Operation:

Description :

140

QC21

FINAL INSPECTION/W/O RELEASE



(40)

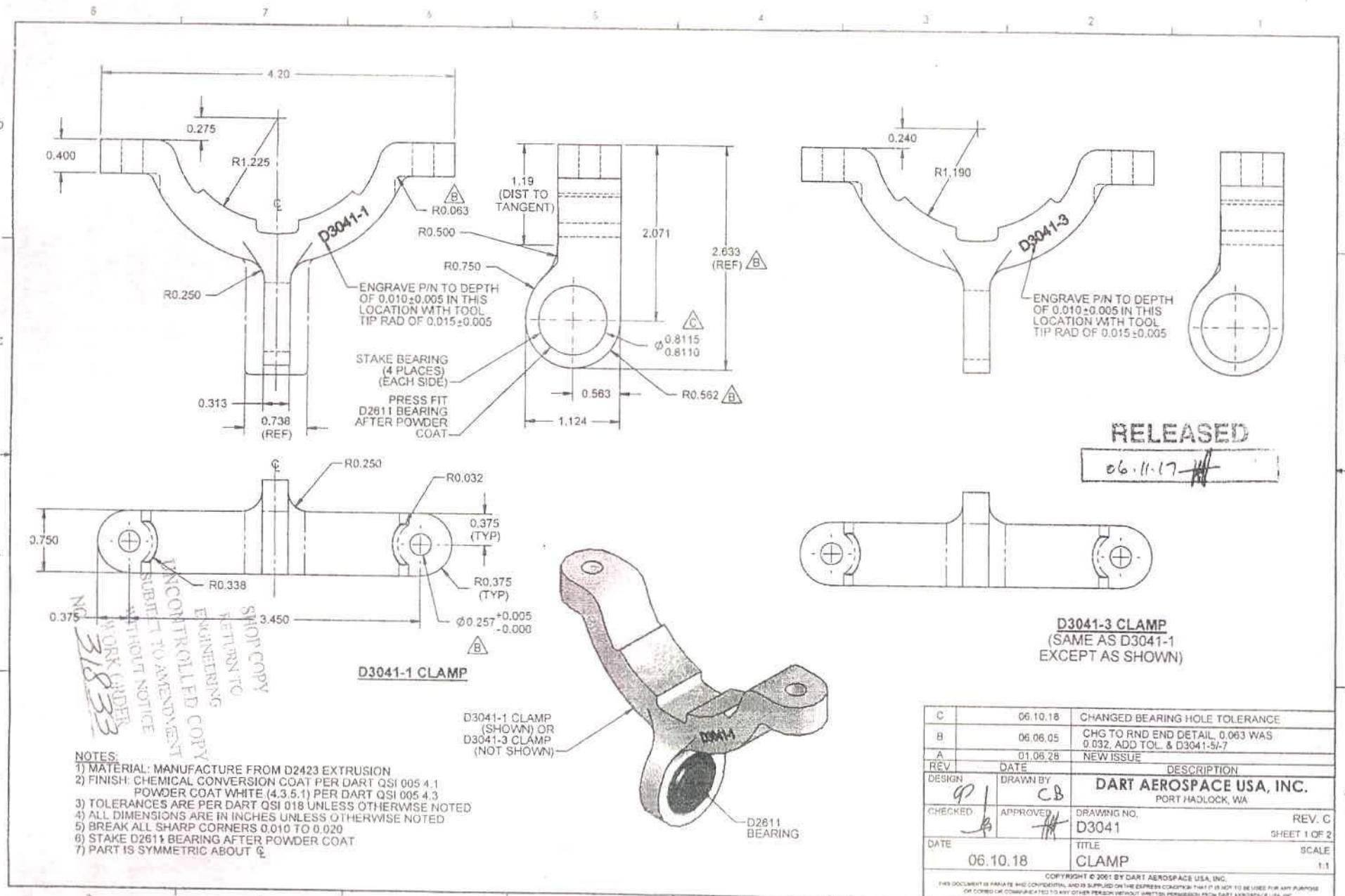
Comment: FINAL INSPECTION/W/O RELEASE

407107109

Job Completion



407107109



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/07/04	11	Split w/o	SJS	07/07/04	39		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries